

G680 7764

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



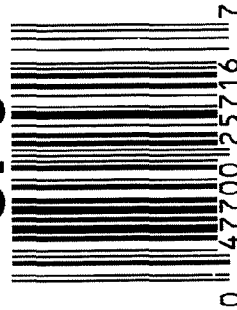
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807764

UPC



M24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807764

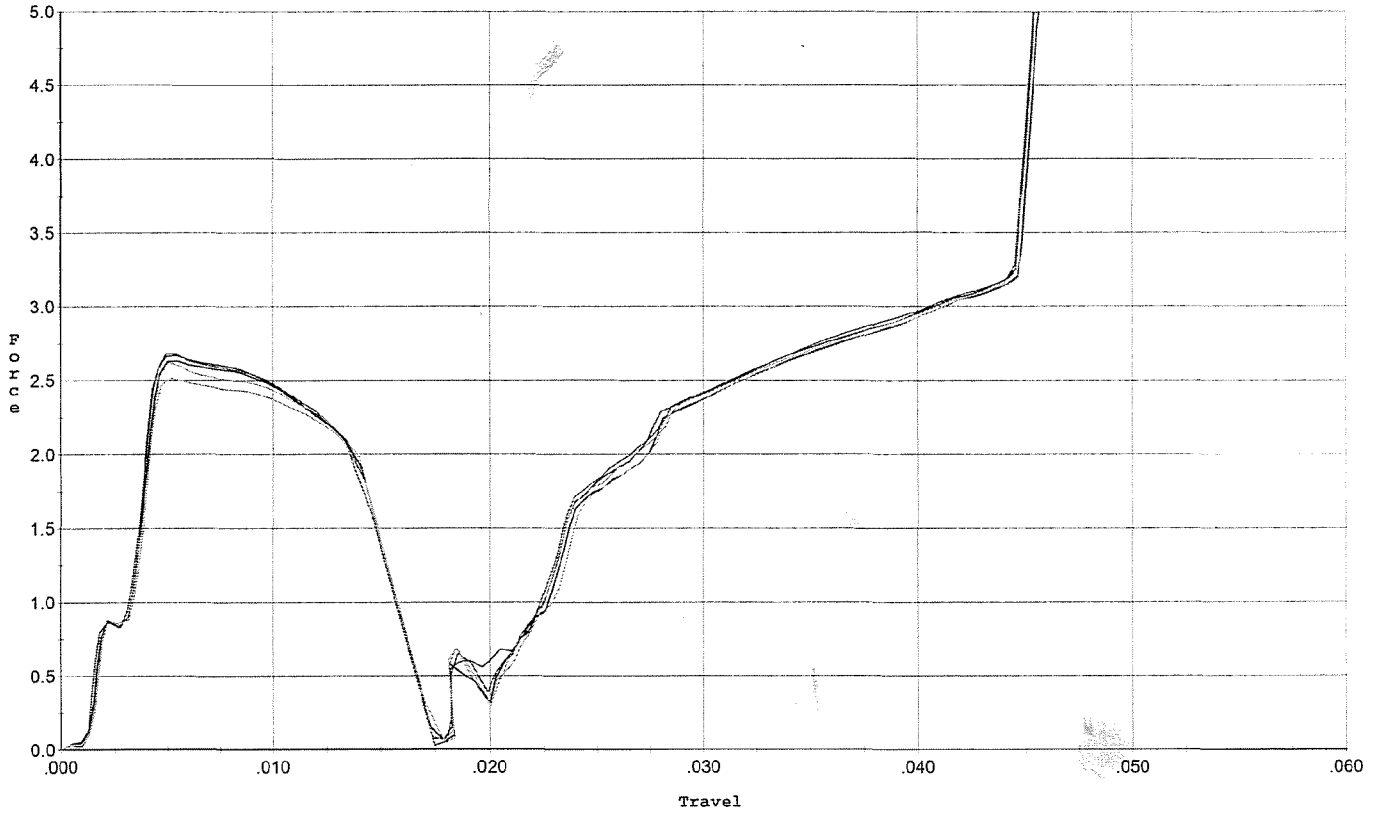
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX MARK 05 2009 OPERATOR 10	2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	SPC
480	MAGNAFLUX BBL ACTION		3/5/09	AD
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	MR
540	APPLY COATINGS (BARREL ACTION)		3/9	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-11-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-19-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-19-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	3-19-09	WV
	J) ASSEMBLE STOCK		3-11-09	SPS
	K) ASSEMBLE SWIVEL STUDS		3-19-09	WV
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-16-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-19-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.70</u> <u>2.76</u> <u>2.70</u> <u>2.66</u>	3-18-09	TL
	C) FUNCTION		3-19-09	WV
690	PACK		3/20/09	FM

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .50 lb



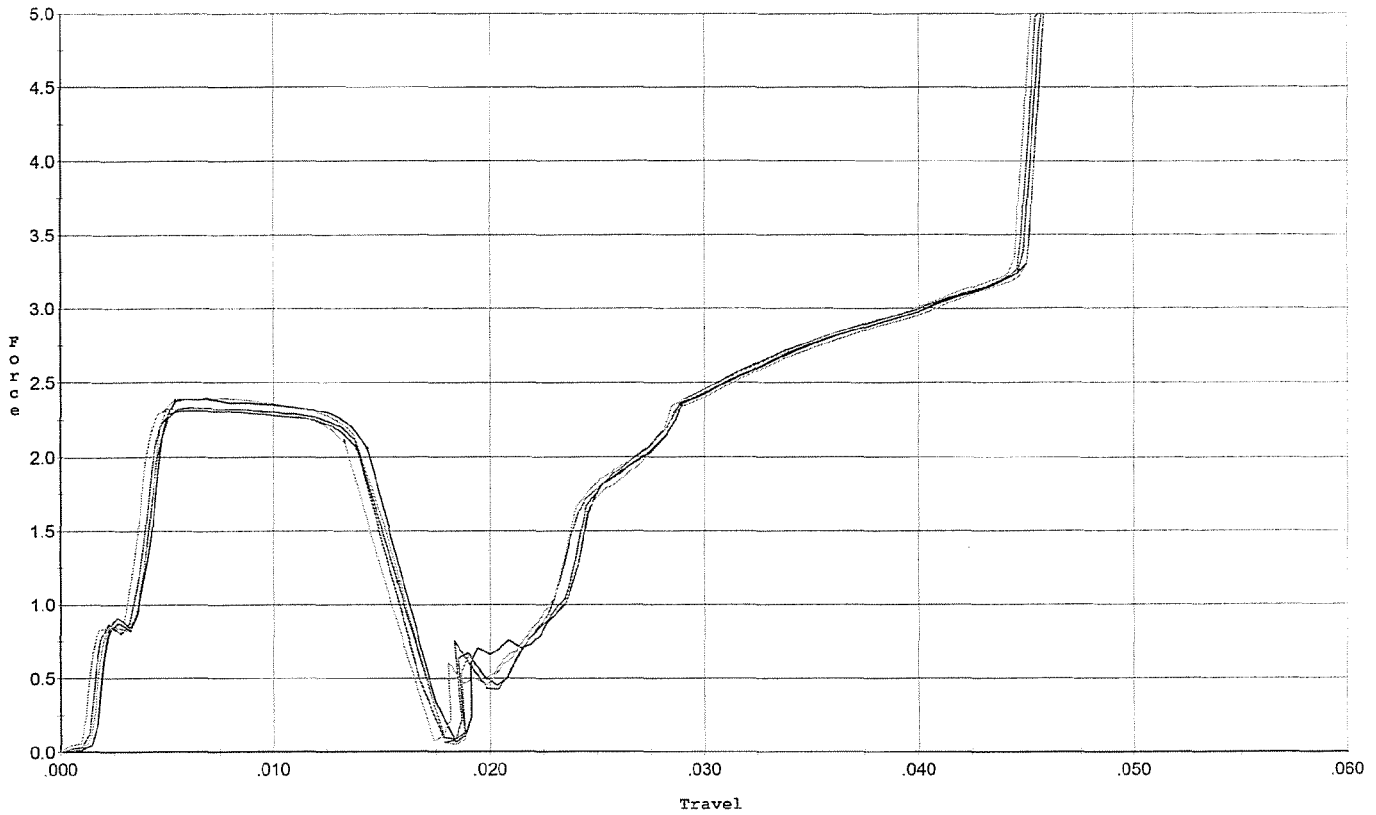
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.014	0.00	0.034	0.026		Set Trigger
2	2.636	0.014	0.00	0.034	0.025		Set Trigger
3	2.684	0.015	0.00	0.034	0.026		Set Trigger
4	2.624	0.014	0.00	0.034	0.024		Set Trigger
5	2.516	0.014	0.00	0.034	0.024		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 50 cycles+/- .50 lb



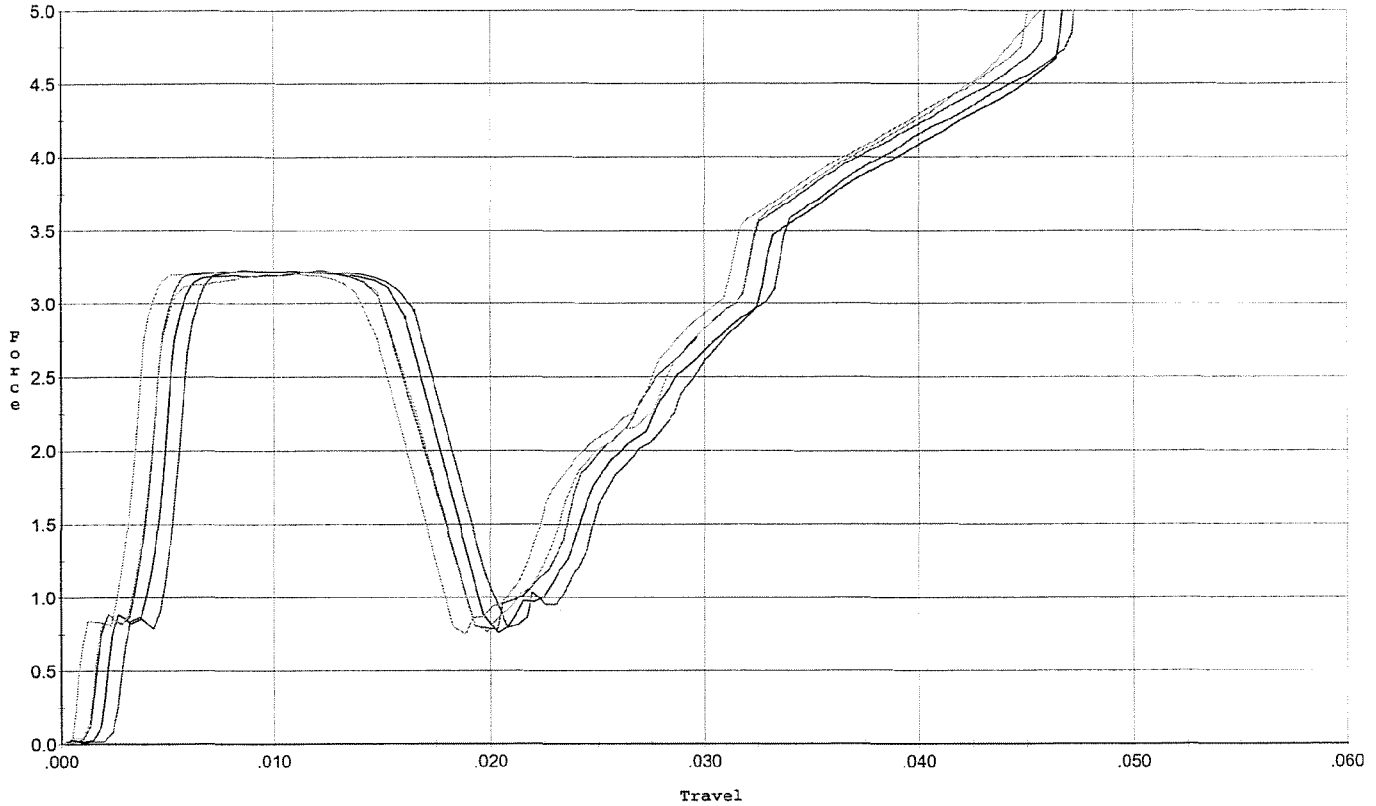
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.331	0.016	0.00	0.034	0.026		Set Trigger
2	2.390	0.014	0.00	0.034	0.024		Set Trigger
3	2.309	0.014	0.00	0.034	0.023		Set Trigger
4	2.331	0.013	0.00	0.034	0.023		Set Trigger
5	2.396	0.015	0.004	0.034	0.026		Set Trigger

A-235

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .75 lb



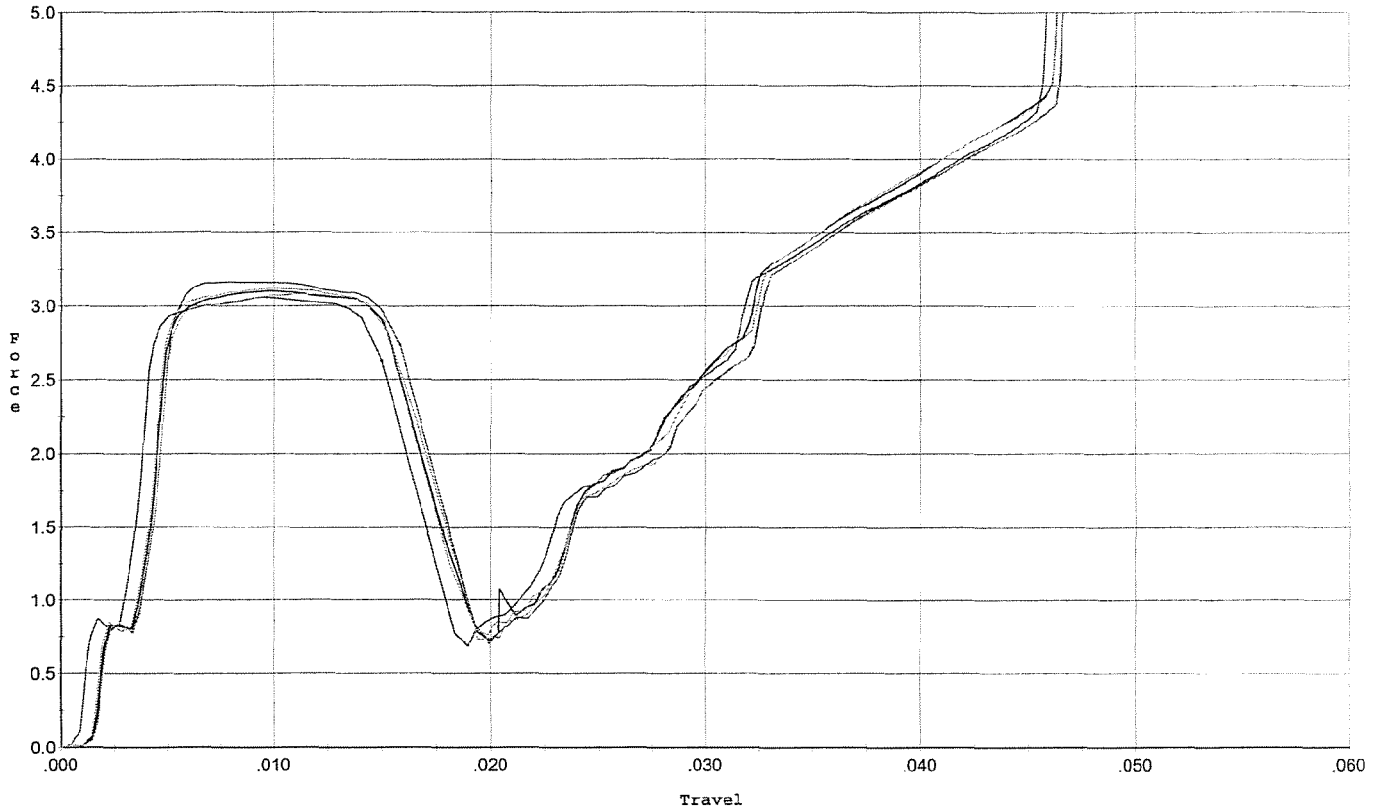
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.229	0.017	0.002	0.032	0.035		Set Trigger
2	3.220	0.016	0.00	0.032	0.035		Set Trigger
3	3.223	0.017	0.00	0.031	0.038		Set Trigger
4	3.219	0.017	0.00	0.031	0.037		Set Trigger
5	3.221	0.015	0.003	0.031	0.035		Set Trigger

1A-3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles+/- .75 lb



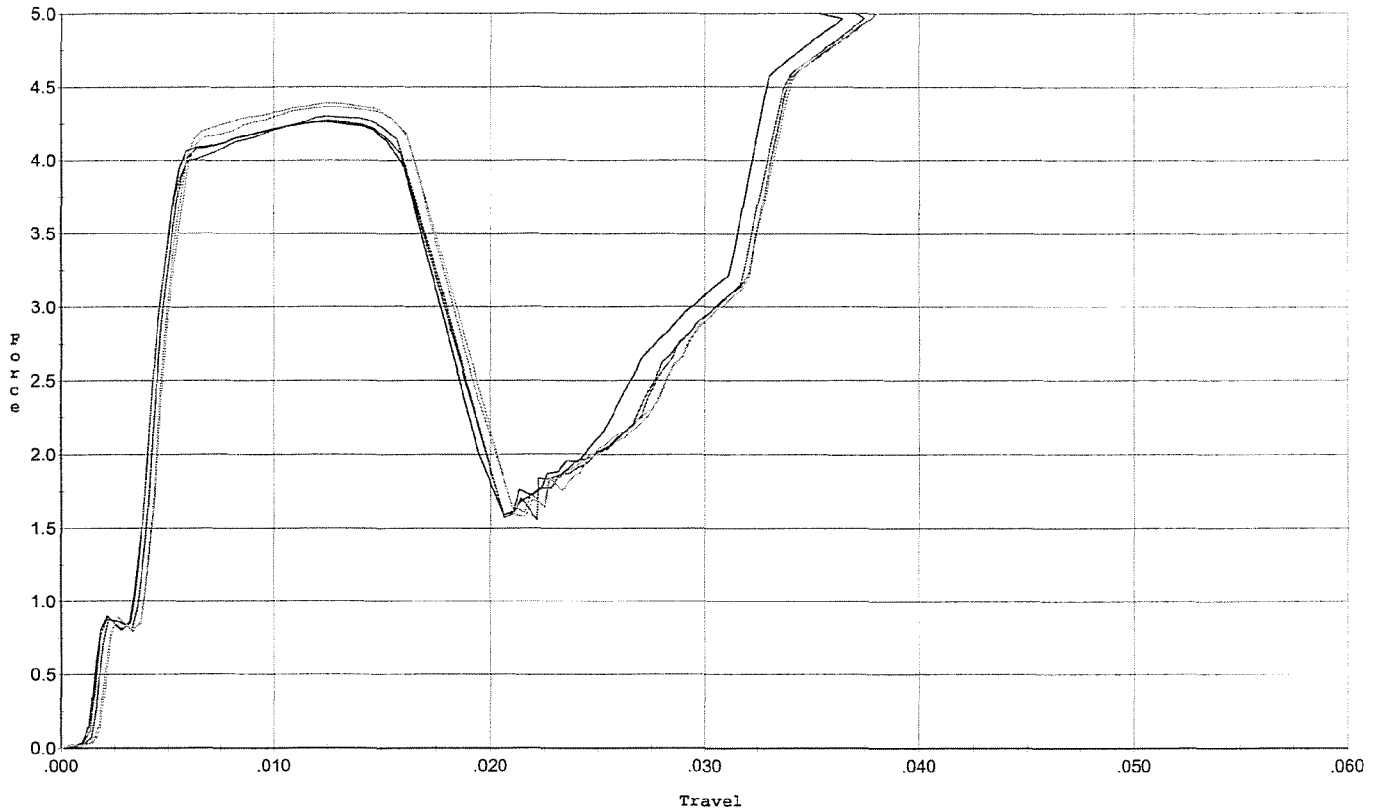
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.060	0.015	0.00	0.032	0.033		Set Trigger
2	3.104	0.015	0.004	0.032	0.032		Set Trigger
3	3.161	0.016	0.00	0.032	0.035		Set Trigger
4	3.119	0.015	0.00	0.032	0.033		Set Trigger
5	3.081	0.017	0.00	0.032	0.035		Set Trigger

A-3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



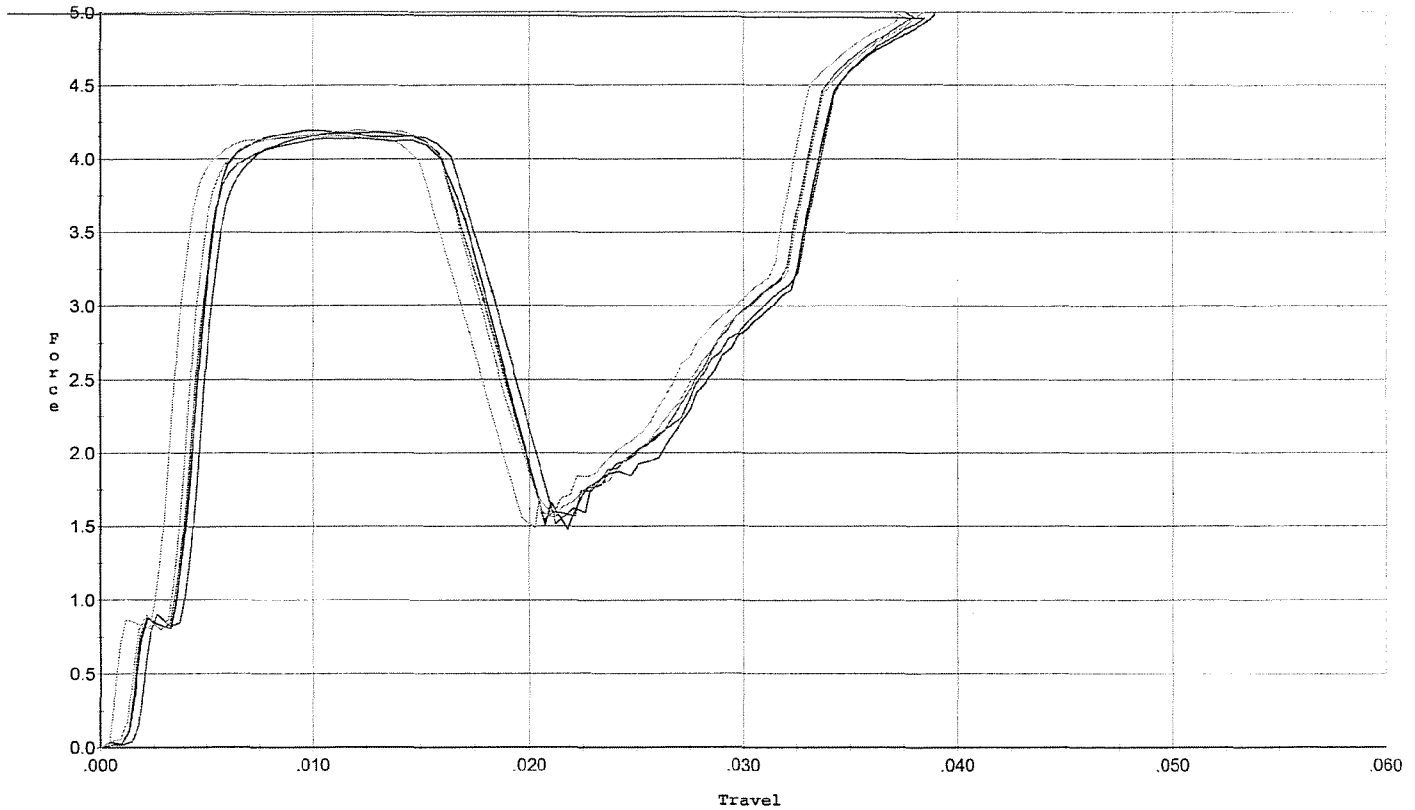
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.272	0.018	0.004	0.029	0.052		Set Trigger
2	4.260	0.016	0.00	0.029	0.046		Set Trigger
3	4.300	0.018	0.00	0.028	0.052		Set Trigger
4	4.364	0.018	0.00	0.029	0.053		Set Trigger
5	4.393	0.016	0.00	0.029	0.047		Set Trigger

A-4.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cycles+/- 1.0 lb



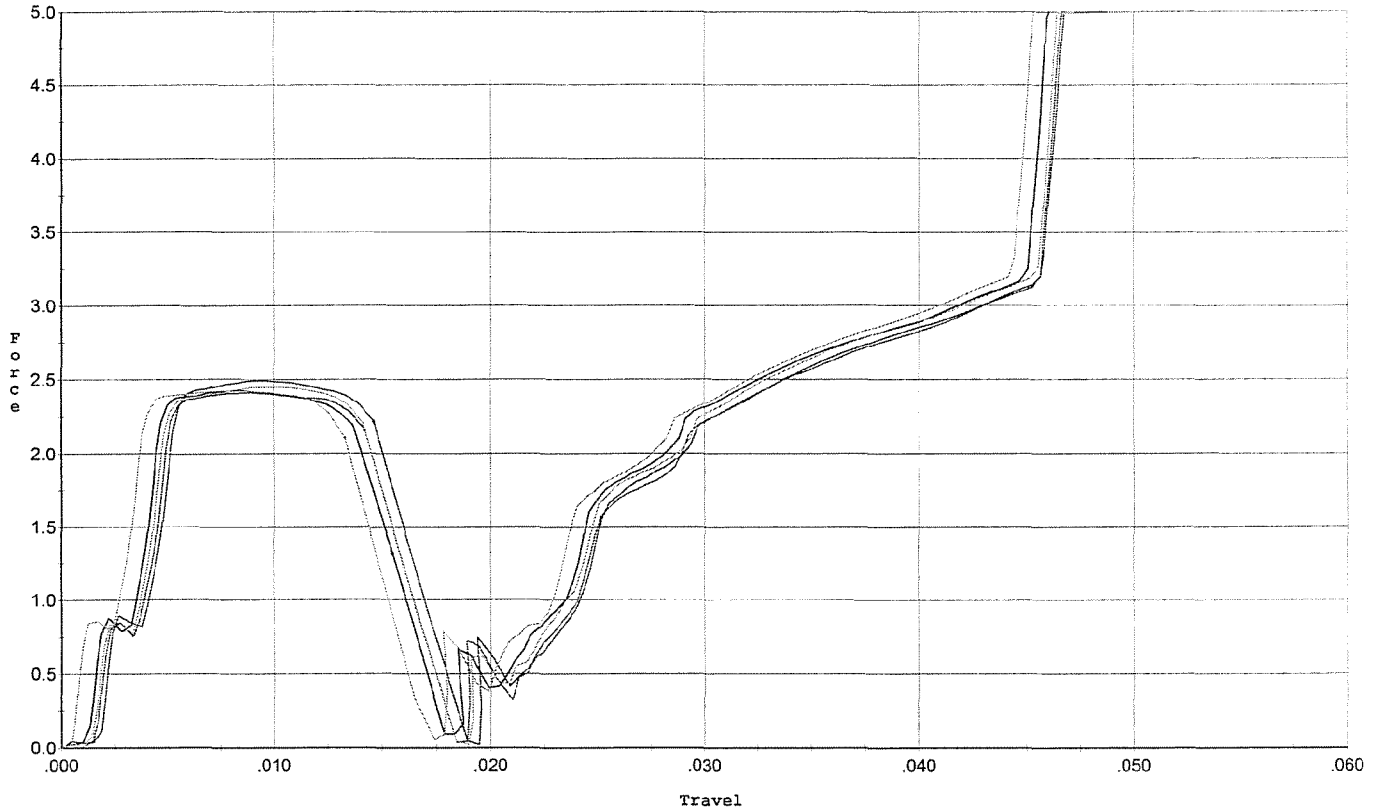
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.180	0.018	0.00	0.029	0.051		Set Trigger
2	4.196	0.017	0.004	0.029	0.049		Set Trigger
3	4.140	0.018	0.00	0.029	0.051		Set Trigger
4	4.157	0.017	0.003	0.029	0.051		Set Trigger
5	4.198	0.016	0.00	0.030	0.046		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs +/- .50 lb for target & accuracy



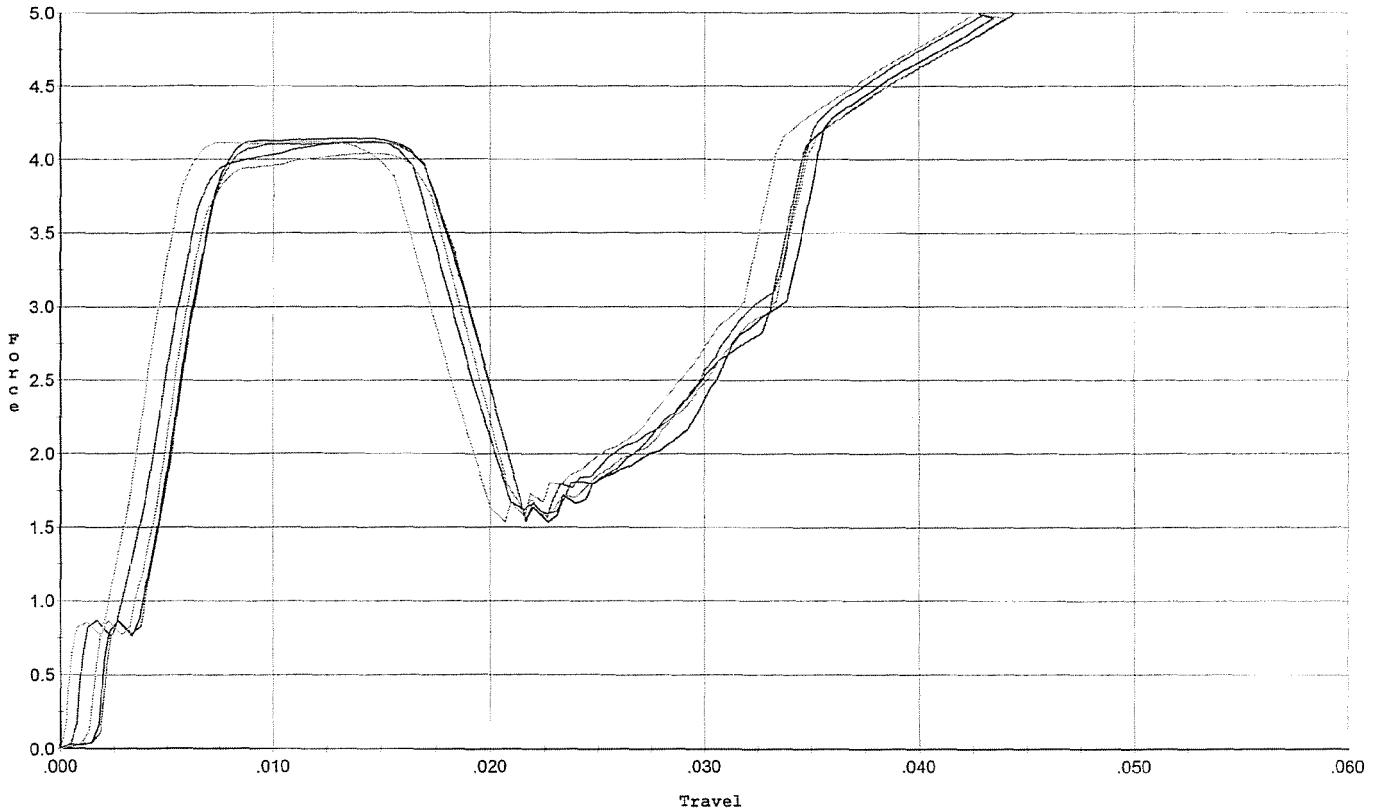
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.492	0.015	0.002	0.035	0.025		Set Trigger
2	2.428	0.015	0.00	0.034	0.026		Set Trigger
3	2.412	0.014	0.00	0.035	0.024		Set Trigger
4	2.450	0.014	0.004	0.035	0.024		Set Trigger
5	2.428	0.013	0.00	0.034	0.024		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.017	0.00	0.031	0.046		Set Trigger
2	4.144	0.019	0.00	0.030	0.051		Set Trigger
3	4.120	0.018	0.00	0.030	0.050		Set Trigger
4	4.121	0.016	0.00	0.030	0.045		Set Trigger
5	4.043	0.017	0.00	0.031	0.047		Set Trigger

A-4.11